

54323 Derew

Work Order ID 53450

November 6, 2009 8:17:08 AM

Page 1

Item ID: D2230-3

Accept

Revision ID: G

Item Name: Lug

Start Date: 05/11/2009 Start Qty: 100.00

Required Date: 13/11/2009 Req'd Qty: 100.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan: BLDate: 09-11-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Band Saw ☐ Cut D2423 extrusion to 0.82" ☐ Batch: 43722

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio D2230-3 ☐ Check for crack while loading into the machine.

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mf 09/11/22

100

mf/SP 09/12/01

100

SP 09/11/30

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Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Lug

Start Date: 05/11/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

09.12.03



QC

Memo

0.00

Quality Control

100

140

~~Small Fab~~

0.00

N/A 09.12.03



~~Small Fab~~

~~Memo~~

0.00

~~Small Fab~~

~~Tumble and deburr rough edges after tumbling~~

150

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/12/03



HandFinish

Memo

0.00

Hand Finishing

X100

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Page 3

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Setup Start



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Stop



Item Name: Lug

Start Date: 05/11/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

ML 09/12/03

100 0

Memo

0.00

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

11/2/03

0.00

Memo

0.00

= 7 ML 09/12/04

(100) 0

START TIME:

8:30am

OVEN TEMPERATURE:

9:00pm FINISH TIME:

320°F

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

MD 09/12/04

100

Memo

0.00

Work Order ID 53450

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Page 4

Item ID: D2230-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Lug

Start Date: 05/11/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
200 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

9/12/07 SL (100)

09/12/08 JF

UME
09-12-07

Picklist Print

November 6, 2009 8:17:13 AM

Page 1

Work Order ID: 53450



Parent Item: D2230-3RevG



Parent Item Name: Lug

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3PRevF		Purchased	No			100	Each	0.0000	100.0000			
LUG												
D2423RevB1		Manufactured	No			100	f	658.6339	7.1895			
Lug Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

658.6339221

→ 43722

207.263091

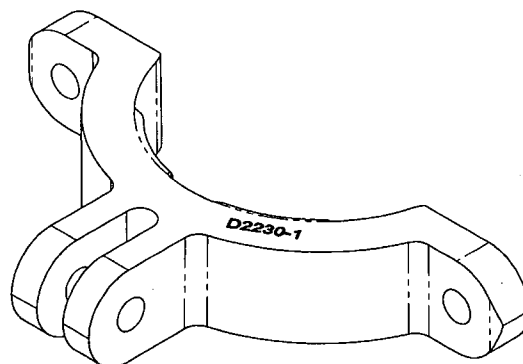
44529

22.39

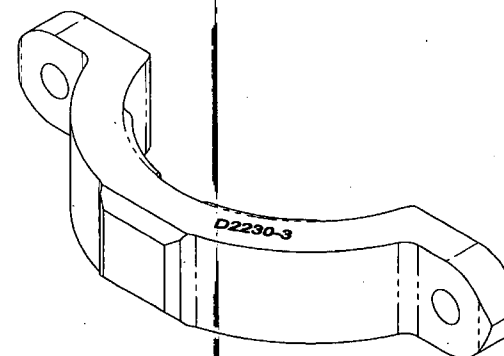
45800

428.980832

7.1895 *ml 09/11/22*



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53450
MR 09-11-5

RELEASED
01/06/2016

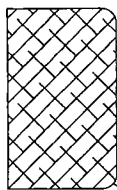


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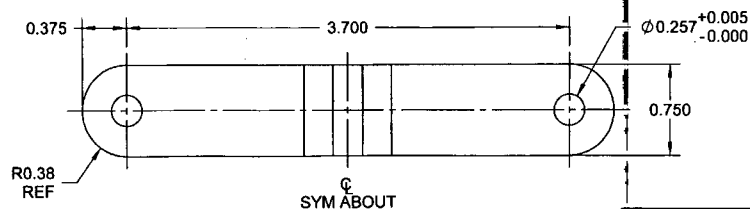
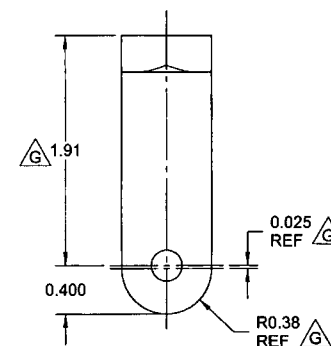
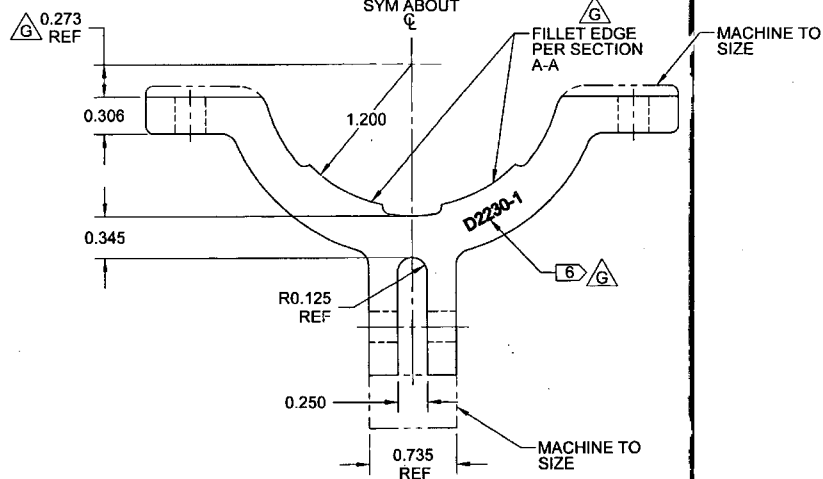
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



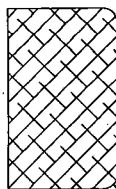
D2230-1 MOUNTING LUG

RELEASED
09/06/25 M

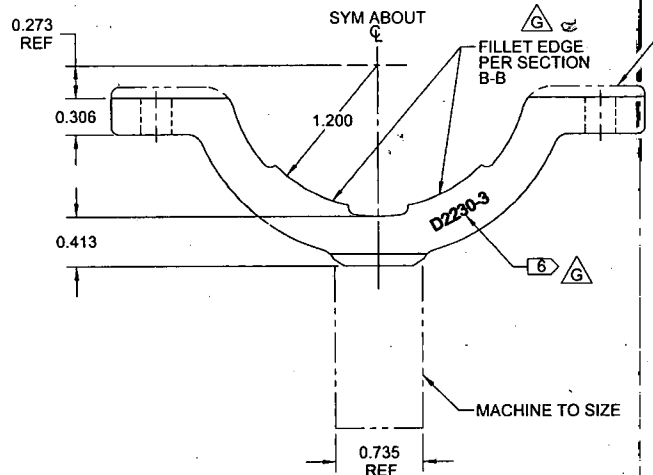
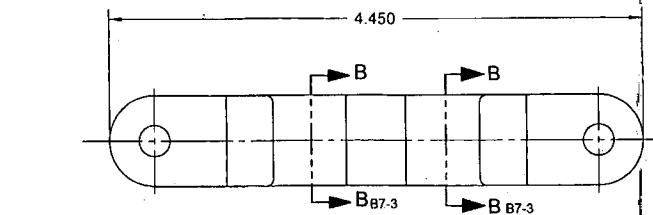
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
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DE APPR.		MOUNTING LUG	NTS
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W/O 533 5345C

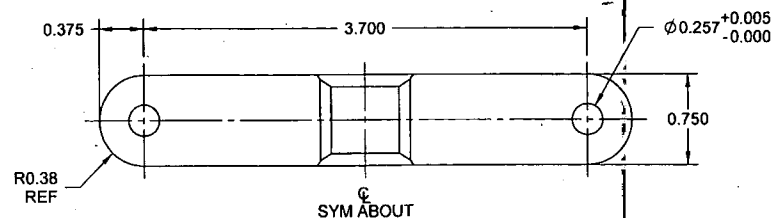
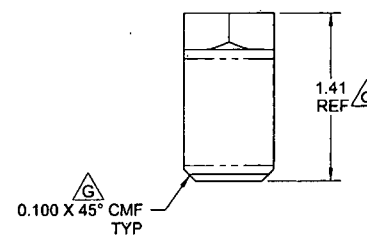
SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



MACHINE TO SIZE



D2230-3 MOUNTING LUG

RELEASED
09/06/2016

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
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W/0 53450